

ASAP

Split.

Dart Aerospace Ltd.

Date: Thursday, 25/10/2007 2:34:52 PM  
User: Linda Lacelle

## Process Sheet

|                       |                                       |                  |                               |
|-----------------------|---------------------------------------|------------------|-------------------------------|
| Customer              | : CU-DAR001 Dart Helicopters Services | Drawing Name     | : SHAFT SLEEVE                |
| Job Number            | : 35400 - 1                           |                  |                               |
| Estimate Number       | : 11155                               | Part Number      | : D32337                      |
| P.O. Number           | : N/A                                 | Drawing Number   | : D3233 REV B                 |
| This Issue            | : 25/10/2007 S.O. No. : N/A           | Project Number   | : N/A                         |
| Prsht Rev.            | : NC                                  | Drawing Revision | : B                           |
| First Issue           | : N/A Type : MACHINED PARTS           | Material         | : N/A                         |
| Previous Run          | : 28618                               | Due Date         | : 01/11/2007 Qty: 14 Um: Each |
| Written By            | : _____                               |                  |                               |
| Checked & Approved By | : _____                               |                  |                               |
| Comment               | : Est. A 05.03.14 New issue KJ/JLM    |                  |                               |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description :         |
|---------|-----------------------|-----------------------|
| 1.0     | M1020TR1375W125       | COLD DRAWN ROUND TUBE |



Comment: Qty.: 0.1860 f(s)/Unit Total : 2.6034 f(s)

1020-1025 Round Tube

Material: AISI 1020-1025 Seamless Round Tubing Cold Drawn per MIL-T-5066 or ASTM A513-00 MT1020

SRA or AMS 5075 or AMS 5077

(M1020TR1.375W.125)

Identify for D3233-7

Batch: M10325B

|     |             |                    |
|-----|-------------|--------------------|
| 2.0 | LATHE CONV. | CONVENTIONAL LATHE |
|-----|-------------|--------------------|



Comment: CONV.LATHE

Turn as per Dwg D3233

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

|     |               |                              |
|-----|---------------|------------------------------|
| 5.0 | MILLING CONV. | CONVENTIONAL MILLING MACHINE |
|-----|---------------|------------------------------|



Comment: CONVENTIONAL MILLING MACHINE

Deburr

N/A

JLM

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: JD Date: 04/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Thursday, 25/10/2007 2:34:52 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHAFT SLEEVE

Job Number: 35400

Part Number: D32337

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W523

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*W 07.11.20*



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

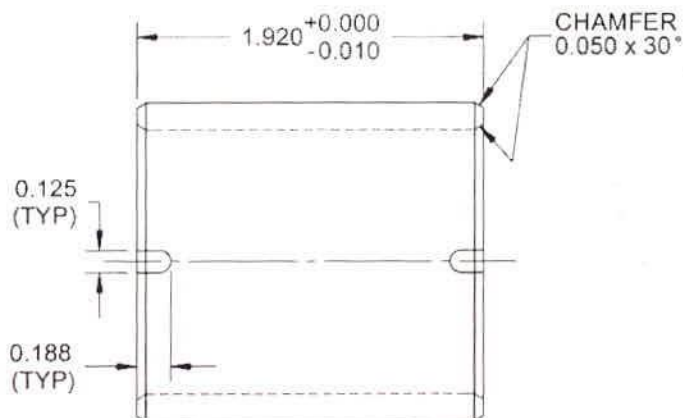
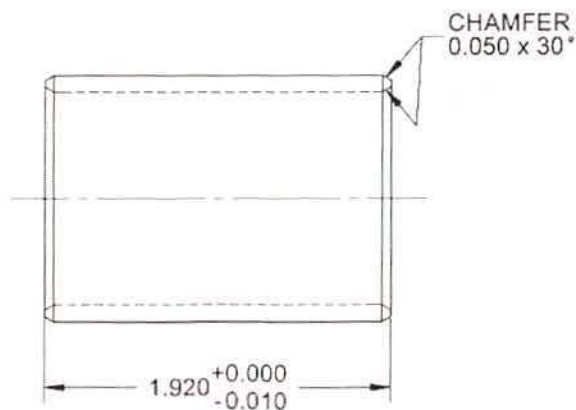
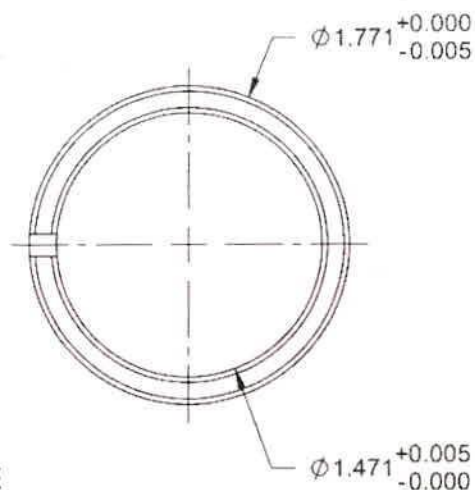
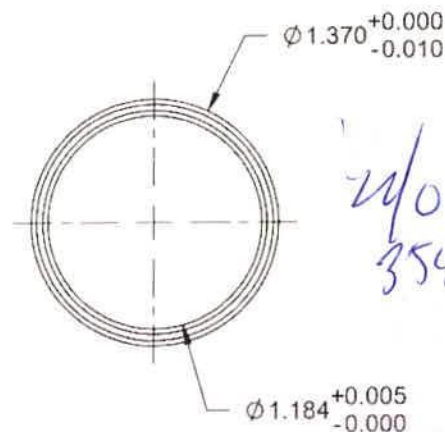
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

**DART**

|                  |                         |   |                        |
|------------------|-------------------------|---|------------------------|
| DESIGN           | DRAWN BY                | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>F7    | APPROVED<br>WSS         | DRAWING NO.<br>D3233                              | REV. B<br>SHEET 3 OF 3 |
| DATE<br>05.03.08 | TITLE<br>WHEEL ASSEMBLY |   | SCALE<br>1:1           |

**D3233-5 HUB SLEEVE****D3233-7 SHAFT SLEEVE****NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00  
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS  
(REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

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ST → x 1.2948 1.307.

2.092 054

Fin-21-188

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

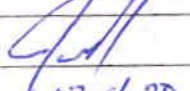



|                           |      |                      |
|---------------------------|------|----------------------|
| DART AEROSPACE LTD        |      | Work Order: 35400    |
| Description: Shaft Sleeve |      | Part Number: D3237-7 |
| Inspection Dwg:           | Rev: | Page 1 of 1          |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Inspection Sheet<br>Drawing Dimension | Tolerance  | Actual<br>Dimension | Accept | Reject | Method of<br>Inspection | Comments |
|---------------------------------------|------------|---------------------|--------|--------|-------------------------|----------|
| A 1.920                               | $\pm .010$ | 1.913               | -      |        |                         |          |
| B $\phi 1.370$                        | $\pm .010$ | 1.369               | -      |        |                         |          |
| C $\phi 1.184$                        | $\pm .005$ | 1.1855              | -      |        |                         |          |
| D                                     |            |                     |        |        |                         |          |
| E                                     |            |                     |        |        |                         |          |
| F                                     |            |                     |        |        |                         |          |
| G                                     |            |                     |        |        |                         |          |
| H                                     |            |                     |        |        |                         |          |
| I                                     |            |                     |        |        |                         |          |
| J                                     |            |                     |        |        |                         |          |
| K                                     |            |                     |        |        |                         |          |
| L                                     |            |                     |        |        |                         |          |
| M                                     |            |                     |        |        |                         |          |
| N                                     |            |                     |        |        |                         |          |
| O                                     |            |                     |        |        |                         |          |
| P                                     |            |                     |        |        |                         |          |
| Q                                     |            |                     |        |        |                         |          |
| R                                     |            |                     |        |        |                         |          |
| S                                     |            |                     |        |        |                         |          |
| T                                     |            |                     |        |        |                         |          |
| U                                     |            |                     |        |        |                         |          |
| V                                     |            |                     |        |        |                         |          |
| W                                     |            |                     |        |        |                         |          |
| X                                     |            |                     |        |        |                         |          |
| Y                                     |            |                     |        |        |                         |          |

|  |   |                     |     |
|--|---|---------------------|-----|
| Measured by:  | Audited by:  | Prototype Approval: | N/A |
| Date: 07-11-20   | Date: 07-11-20  | Date:               | N/A |

| Rev | Date | Change    | Revised by | Approved |
|-----|------|-----------|------------|----------|
|     |      | New Issue | KJ/RF      |          |